CLAIMS

1. A method of assembling a head gimbal assembly comprising the following steps performed in the following order:

attaching a head/slider having at least one termination pad to a flex circuit having at least one electrical lead to produce a head/slider circuited gimbal assembly;

electrically connecting the at least one termination pad of the head/slider to the at least one electrical lead of the flex circuit; and

attaching the head/slider circuited gimbal assembly to a suspension.

2. The method of claim 1 and further including:

determining the static angles of the head/slider circuited gimbal assembly after the step of electrically connecting the at least one termination pad of the head/slider to the at least one electrical lead of the flex circuit.

3. The method of claim 2 and further including:

determining the static angles of the suspension prior to the step of attaching the head/slider circuited gimbal assembly to the suspension.

4. The method of claim 3 and further including performing a dynamic electrical test on the head/slider circuited gimbal assembly prior to determining the static suspension angles.

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5. The method of claim 4 and further including determining the offset between the head/slider circuited gimbal assembly prior to attaching it to the suspension.

6. The method of claim 5 wherein said offset is determined according to the following formula:

$$X = -(\Theta_{\text{Circuited Gimbal}} * k_{\textit{Circuited Gimbal}} + \Theta_{\text{Suspension Flexure}} * k_{\text{Suspension Flexure}})/F_{\text{Gram}} - X_0$$

where

$\Theta_{\text{Circuited Gimbal}}$ = static angle of the HSCG assembly;

$k_{\textit{Circuited Gimbal}}$ = stiffness of the HSCG assembly;

$\Theta_{\text{Suspension Flexure}}$ = static angle of the suspension;

$k_{\text{Suspension Flexure}}$ = stiffness of the suspension;

F_{Gram} = Gram Load; and

X_0 = the product of the gram load and the load point shift.

7. The method of claim 1 and further including:

determining the static angles of the suspension prior to the step of attaching the head/slider circuited gimbal assembly to the suspension.

8. The method of claim 1 and further including performing a dynamic electrical test on the head/slider circuited gimbal assembly prior to determining the static suspension angles.

9. The method of claim 8 wherein said dynamic electrical test is performed by flying the head/slider circuited gimbal assembly over a rotating media disk.

10. The method of claim 1 and further including determining the offset between the head/slider circuited gimbal assembly prior to attaching it to the suspension.

11. The method of claim 10 wherein said offset is determined according to the following formula:

$$X = -(\Theta_{\text{Circuited Gimbal}} * k_{\textit{Circuited Gimbal}} + \Theta_{\text{Suspension Flexure}} * k_{\text{Suspension Flexure}})/F_{\text{Gram}} - X_0$$

where

$\Theta_{\text{Circuited Gimbal}}$ = static angle of the HSCG assembly;

$k_{\textit{Circuited Gimbal}}$ = stiffness of the HSCG assembly;

$\Theta_{\text{Suspension Flexure}}$ = static angle of the suspension;

$k_{\text{Suspension Flexure}}$ = stiffness of the suspension;

F_{Gram} = Gram Load; and

X_0 = the product of the gram load and the load point shift.